

Work Order ID 65837

Wednesday, January 26, 2011 11:32:16 AM



Page 1

Item ID: D2053

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 1/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 1-01-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2053

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2053

Dwg Rev: *E*Prog Rev: *E*

****grain direction along 1.987" ****

2-Deburr if necessary

*B11-2-7**(15)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D2053 using CNC Brake

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Required Date: 2/7/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				15.		BR 11-02-9	
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 112588. Memo START TIME: 3:40 OVEN TEMPERATURE: 320° FINISH TIME: 4:10.	0.00 0.00				15.		BR 11-02-9	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				15		d 11/02/10	

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Required Date: 2/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Identify as per dwg & Stock Location: Q05

0.00



Packaging

Memo

0.00

Packaging

11/02/10 MF

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10 MF
11-02-10

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Picklist Print

Wednesday, January 26, 2011 11:32:22 AM

Page 1

Work Order ID: 65837



Parent Item: D2053



Parent Item Name: Mounting Bracket


Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP D02.03.18 Added Rev.B NG (Issue this IPP with part number D2052)
 IPP Rev:E now water jet 07-10-25 DD
 IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090  5052-H32 .090 Sheet		Purchased	No			100	sf	29.3000	0.0385	0.486316	.7 B11-2-7		
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT22		29.3					
						100782		0.8					
						3019		28.5					
										3019			

(15)

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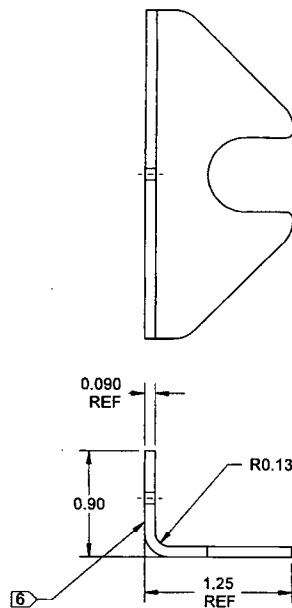
8 7 6 5 4 3 2 1

D

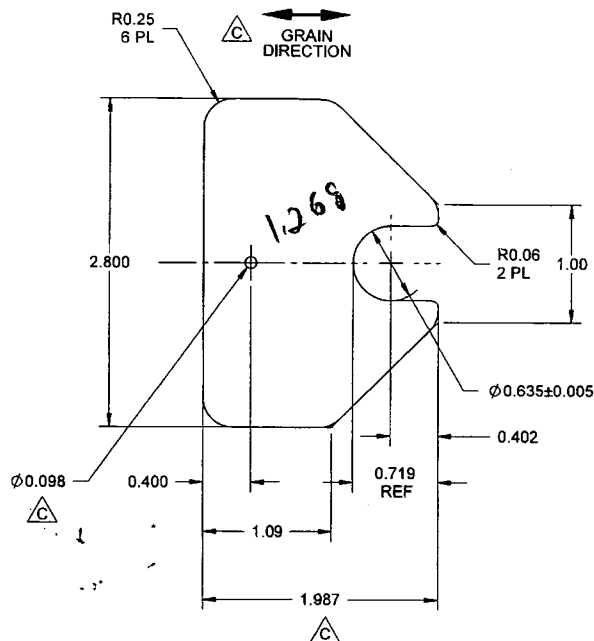
C

B

A



D2053 BRACKET



D2053F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65837

Pl 11-01-24
RELEASED
08-05-13

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090)
OR
6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (REF DART SPEC M6061T6S.090)
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.04 lbs

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD Ø0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) Ø0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT	PH	08.04.25
B	Ø0.635 WAS Ø0.437; 0.635 WAS 0.325	DS	02.03.12
A	NEW ISSUE	DS	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.04.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2053	REV. C SHEET 1 OF 1
TITLE BRACKET	SCALE NTS
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